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D2010-104
Job Sheet 206529



Part No: D2010-104

Job Qty: 6 pcs

Part Name: Arm



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/3/20

Job Tracking No:

Due Date: 2/17/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP A 04.02.17 New issue KJ/JLM IPP Rev:B 08-05-27 as per ECN1195P DD verified by:EC IPP
Rev:C 08-06-20 rev.D as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - Brake NC	6 pcs	2/17/20		0.25	1.95	Small Fab - Brake - 1		GP 20-02-05
							Small Fab - Brake - 2		
							Small Fab - Brake - 3		
110	Small Fab - 2 - B4B	6 pcs	2/17/20		0.00	1.50	Small Fab - 1 - B4B		GP 20-02-05
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
							Small Fab - 9 - B4B		
							Small Fab - Various 1 - B4B		
120	Small Fab - 3 - B4B	6 pcs	2/17/20		0.00	1.23	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
							Small Fab - 9 - B4B		
							Small Fab - Various 1 - B4B		
130	QC 5	6 pcs	2/17/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		

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CART
AEROSPACE

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Container No: S253440

Part: D2010-104
Job No: 206529
Serial No/Batch: S253440

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/05/20

				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
140 Powdercoat - 4 Black Sand - B4B	6 pcs	2/17/20	0.00 0.18	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
150 QC 3	6 pcs	2/17/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
160 Packaging 3-1 - Stock - B4B	6 pcs	2/17/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	

DAS
81
FEB 05 2020

DAS
82
9-89

20-02-6

838

DAS
82
9-89

FEB 06 2020

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	DAS 57 351
				Packaging 3 - 24 - B4B	84
				Packaging 3 - 25 - B4B	9-89
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	DAS
170 QC 21 - SA	6	2/17/20	0.00 0.00	QC 21 - SA - 21	21
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 53	

FEB 07 2020

Part Op 100 - (Punch ends and deburr as per dwg), Punch per Dwg. D2010-104 and Spec Control Dwg D2727 Identify as D2010-Descriptions: 104

110 - 1- Bend as per Dwg D2010 using bending Jig D2010-104T2 2- flare before installing plug as per dwg D2010 3- Install D2057 plug as per Dwg D2010

120 - 1- flare before installing plug as per dwg D2010 2- Install D2057 plug as per Dwg D2010

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3), START TIME: 11:10 OVEN TEMPERATURE: 320°

150 - (QC3- Inspect Part Finish)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.500W.049	304 Round Tube .500 X .049W	9 ft (1.5 ea)	100-Small Fab - Brake NC	232352 x 2.28563 x 4
D2057 126	Plug	6 pcs (1 ea)	110-Small Fab - 2 - B4B	233587

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - Brake NC	M304TR0.500W.049	9	158	0
110-Small Fab - 2 - B4B	D2057	6	16	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	7.900inches ± 0.030	7.930 7.870		
2	Arm	10.200 ± 0.030			
3	Arm	45.000Degree ± 0.500	45.500 44.500		
4	Arm	45.000Degrees ± 0.500	45.500 44.500		
5	Arm	0.600inches + 0.008 - 0.001	0.608 0.599		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					